

## VERSION OF AMENDMENTS SHOWING MARKINGS

### In the Claims

1. (Canceled)
2. (Canceled).
3. (Canceled)
4. (Canceled)
5. (Canceled)
6. (Canceled)
7. (Canceled)
8. (Canceled)
9. (Canceled)
10. (currently Amended) A method of enhanced gravity casting comprising:
  - directing a charge of molten lead into a chamber located in fluid communication with a battery part cavity;
  - allowing the battery part cavity to fill with molten lead under a gravity flow condition;
  - forming the shutoff member with a dimension less than the dimensions of the chamber so that when the shutoff member is in the closed condition the molten lead remains in a molten state around the shutoff member
  - extending a the shutoff member located in the molten lead in the chamber into engagement with a mold inlet passage while the molten lead is in a liquid state to close off the inlet passage and prevent further gravity flow of molten lead into the mold cavity; and
  - maintaining a following force to generate sufficient pressure on the shutoff member as the molten lead solidifies to allow the shutoff member to follow a volume contraction of the molten lead in the mold cavity to thereby form an enhanced gravity casting.

11. (original) The method of claim 10 allow and end face of the shutoff member to be brought into substantial alignment with a face of the mold cavity as the volume contraction occurs during the solidification of the molten lead in the battery part cavity.

12. (Cancel)

13. (Currently Amended) A method of enhanced gravity casting comprising:  
directing a charge of molten lead into a chamber located in fluid communication with a  
battery part cavity;  
allowing the battery part cavity to fill with molten lead under a gravity flow condition;  
extending a the shutoff member located in the molten lead in the chamber into engagement  
with a mold inlet passage while the molten lead is in a liquid state to close off the inlet passage and  
prevent further gravity flow of molten lead into the mold cavity;  
maintaining a following force to generate sufficient pressure on the shutoff member as the  
molten lead solidifies to allow the shutoff member to follow a volume contraction of the molten  
lead in the mold cavity to thereby form an enhanced gravity casting; and

~~The method of claim 10 wherein the~~ maintaining the shutoff member and the inlet passage ~~are maintained~~ with sufficient clearance therebetween to permit air to escape from the molten lead in the cavity but insufficient to permit molten lead to escape therepast.

14. (original) The method of claim 10 including the step of applying a following force to the shutoff member through a moveable piston.

15. (original) The method of claim 10 including the step of forming the mold inlet passage on a top side of the battery part cavity.

16. (original) The method of claim 10 including the step of lowering the shutoff member into the fluid inlet passage while molten lead is present in the inlet passage.

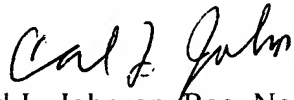
17. (currently amended) The method of claim 16 including the step of maintaining a following force on the shutoff member when the shutoff member is in engagement with the inlet passage to permit the shutoff member to follow a the volume contraction of the molten lead as the molten lead solidifies.

18. (original) The method of claim 10 wherein an internal volume reduction due to shrinkage is solely compensated by maintaining a following force on the molten lead until the molten lead solidifies.

19. (Currently Amended) A method of enhanced gravity casting comprising:  
directing a charge of molten lead into a chamber located in fluid communication with a battery part cavity;  
allowing the battery part cavity to fill with molten lead under a gravity flow condition;  
extending a shutoff member to prevent further gravity flow of molten lead into the mold cavity; and  
maintaining a following force to generate sufficient pressure on the molten lead as the molten lead solidifies to cause a follower to reduce a volume of the battery part cavity in direct response to a volume contraction of the molten lead in the mold cavity to thereby form an enhanced battery part gravity casting; and  
maintaining an air clearance but not a liquid clearance between the shutoff member and an inlet passage to the battery cavity.

20. (Canceled)

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